

Work Order ID **77024****\*77024\***

Page 1

Thursday, November 24, 2011 3:23:29 PM

Item ID: D2154

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Stud Bracket

Start Date: 11/24/2011 Start Qty: 16.00

**\*16\***

Cust Item ID:

Required Date: 12/5/2011 Req'd Qty: 16.00

**\*16\***

Customer:

Reference:

Approvals:

Process Plan: *[Signature]*Date: 11/24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2154	Rev C								

100

0.00

**\*100\***

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2154 Dwg Rev: C Prog Rev: C 2-

Deburr if necessary

*324.063*B11-12-14*(28)*

110

0.00

**\*110\***

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-12-14

120

0.00

**\*120\***

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

*Switzky**counts**(x28)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 77024****\*77024\***

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Thursday, November 24, 2011 3:23:29 PM

Item ID: D2154      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Stud Bracket  
Start Date: 11/24/2011      Start Qty: 16.00      **\*16\***      Cust Item ID:  
Required Date: 12/5/2011      Req'd Qty: 16.00      **\*16\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
<b>*130*</b>	Small Fab	0.00							
Small Fab	Memo								
Small Fab	Deburr if necessary								
	<i>alms</i>								
140	NC BRAKE	0.00							
<b>*140*</b>	Brake NC	0.00							
Brake NC	Memo								
	Form as per Dwg D2154Rev: <i>C</i>			<i>SP 11/12/11</i>		<i>28</i>			
150	QC5- Inspect part completeness to step on W/O	0.00							
<b>*150*</b>	QC	0.00							
Quality Control	Memo			<i>Sub 12/21</i>		<i>counts</i>			
						<i>28</i>			

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NOTE: Date & initial all entries

# Work Order ID 77024

\*77024\*

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Thursday, November 24, 2011 3:23:29 PM

Item ID: D2154 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Stud Bracket  
 Start Date: 11/24/2011 Start Qty: 16.00 \*16\* Cust Item ID:  
 Required Date: 12/5/2011 Req'd Qty: 16.00 \*16\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
*160*									
Powdercoat		0.00							
Powder Coating									
	Memo								
	START TIME: 8:50								
	FINISH TIME: 9:20								
	OVEN TEMPERATURE:								
170	QC3- Inspect Part Finish	0.00							
*170*									
QC		0.00							
Quality Control									
	Memo								
180	Identify as per dwg & Stock Location: 6	0.00							
*180*									
Packaging		0.00							
Packaging									
	Memo								

28X4M-11/12/23

28x 4 11/12/23  
COUNTED

11/12/23 280

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Page 1

Thursday, November 24, 2011 3:23:33 PM

Work Order ID: 77024

**\*77024\***

Parent Item: D2154

**\*D2154\***

Parent Item Name: Stud Bracket

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP: C03.08.08Reformat; Remove TumbleKJ/RF  
IPP Rev:D NowOn Waterjet 07-04-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	303.6000	0.0333	0.560842			
									**				

**\*M304S16GA\***

304/316 Sheet .063

B(11-12-13

Location

Loc Qty

Loc Code

MAT020

303.6

119246

26.6

119653

277

119246

119653

(28)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

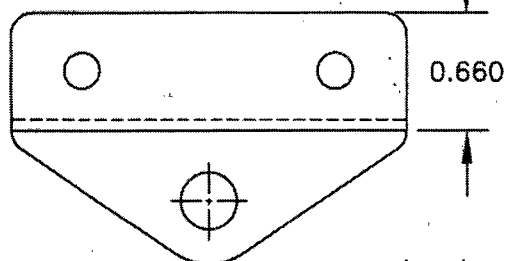
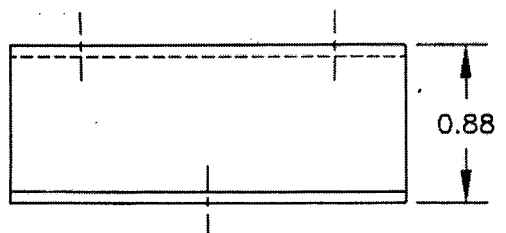
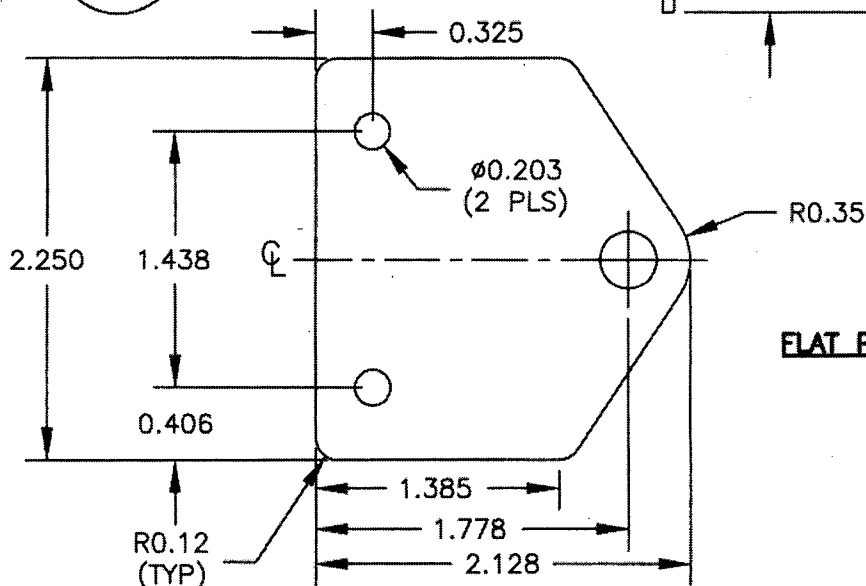
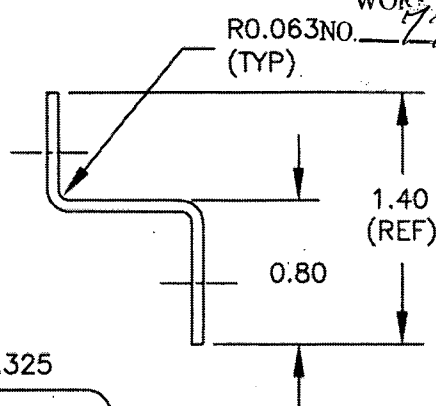
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

DESIGN GH	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2154	REV.-C SHEET 1 OF 1
DATE 04.10.12		TITLE BRACKET, STUD	SCALE 1:1
A	92.07.28	NEW ISSUE	
B	98.09.15	UPDATE FLAT PATTERN; ADD P/COAT	
C	04.10.12	0.88 WAS 0.875; 2.128 WAS 2.068	

**RELEASED**04.10.15 *[Signature]***BEND DETAIL****FLAT PATTERN****D2154 NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)  
2B FINISH 0.063 THICK (M304S16GA)
- 2) FINISH: POWDER COAT WHITE (REF: 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH PART NUMBER AND BATCH NUMBER USING A FINE POINT PERMANENT INK MARKER.

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